

Work Order ID 80811

February-29-12 1:31:31 PM

80811

Page 1

Item ID: D2221

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 350 Basket Base

Stop ***NS2***

Start Date: 29/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 08/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/02/2012* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2221	Rev H
-------	-------

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: *118366*

PLEASE NOTE

IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

Pl 12.03.13

AA 12.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

5/26/13

Quality Control

125

Pressure Wash per QS1005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

XØ M/L 12/23/13

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: 1h10

OVEN TEMPERATURE: 400°F

FINISH TIME: 1h40

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

IXP M / 12/03/15

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

Handwritten signature and date: 12/03/15

Handwritten date: 12/3/15

Handwritten date: 11/203-15

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Picklist Print

February-29-12 1:31:36 PM

Page 1

Work Order ID: 80811

80811

Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 29/02/2012

Required Date: 08/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1		Manufactured	No			100	Each	9.0000	1	1			
J *D2221-1*									**			Pl 12.03.06	
Rib													

Location	Loc Qty	Loc Code
WA	8	
80163	8	1
WA006	1	
72297	1	

D2221-5		Manufactured	No			100	Each	10.0000	2	2			
J *D2221-5*									**			Pl 12.03.06	
Rib													

Location	Loc Qty	Loc Code
WA006	10	
67117	2	
78637	8	2

D2221-7		Manufactured	No			100	Each	2.0000	1	1			
J *D2221-7*									**			Pl 12.03.06	
Rib													

Location	Loc Qty	Loc Code
WA006	2	
73203	2	1

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Page 2

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80811

Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 29/02/2012

Required Date: 08/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100

Each

12.0000

2

2

**

✓ *D2232-3*

Basket Hinge

PL 12.03.06

Location

Loc Qty

Loc Code

WA005

12

75581

2

78903

10

D2235-1

Manufactured No

100

Each

21.0000

2

2

**

✓ *D2235-1*

Basket Rib

PL 12.03.06

Location

Loc Qty

Loc Code

WA

5

78636

5

WA005

16

66895

4

79153

12

D2581

Manufactured No

100

Each

47.0000

2

2

**

✓ *D2581*

Mounting Bracket

PL 12.3.06

Location

Loc Qty

Loc Code

WA005

47

69739

1

70766

2

77045

15

77523

29

D3442-1

Manufactured No

100

Each

7.0000

2

2

**

✓ *D3442-1*

Shim

PL 12.03.06

Location

Loc Qty

Loc Code

WA005

7

71783

7

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Shop Packet Print

Page 2

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Page 3

Work Order ID: 80811

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 29/02/2012

Required Date: 08/03/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041 Manufactured No

D3825-041

Rib Assembly (Basket End)

D3826-041 Manufactured No

✓ ***D3826-041***

Rib / Gusset Assembly

D3827-041 Manufactured No

✓ ***D3827-041***

Rib Assembly (Inboard)

D3832-1 Manufactured No

✓ ***D3832-1***

Mesh (Base)

D3833-1 Manufactured No

✓ ***D3833-1***

Mesh (Base End Face)

Location

WA005

77676

Loc Qty

4

4

Loc Code

100

Each

6.0000

1

1

**

Location

WA006

72729

77546

Loc Qty

6

1

5

Loc Code

100

Each

2.0000

1

1

**

Location

WA006

78635

Loc Qty

2

2

Loc Code

100

Each

11.0000

2

2

**

Location

WA

77521

WA035

79335

Loc Qty

9

9

2

2

Loc Code

2

2

**B78638

Pl 12.03.06

**

Pl 12.03.06

**

Pl 12.03.06

**

Pl 12.03.07

**

Pl 12.03.07

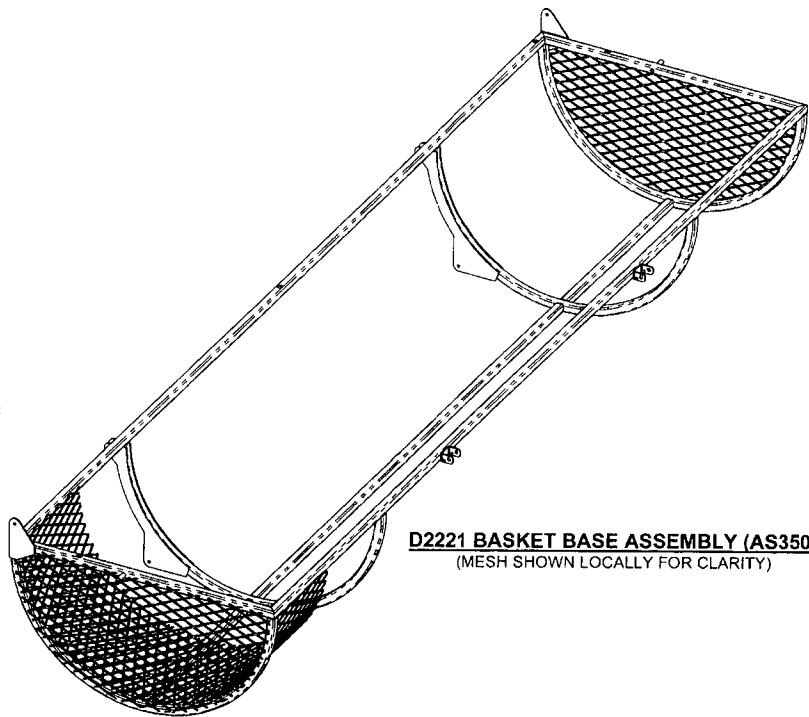
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

H

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

80811 MLJ
12/02/29

RECEIVED
08/11/10

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN 03-1); REVISED SECTIONS A-A, B-B AND C-C (ZN 06-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-11-51-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED. DRAWING TRANSFERRED TO "B" FORMAT.	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21

REV.	DESCRIPTION	BY	DATE
DESIGN	BW		
DRAWN			
CHECKED	SS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2221** REV. H
SHEET 1 OF 5
TITLE **BASKET BASE ASSEMBLY (350)** SCALE NTS

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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 42.00 lbs APPROX
 - 8) MASK ALL HOLES PRIOR TO POWDER COATING

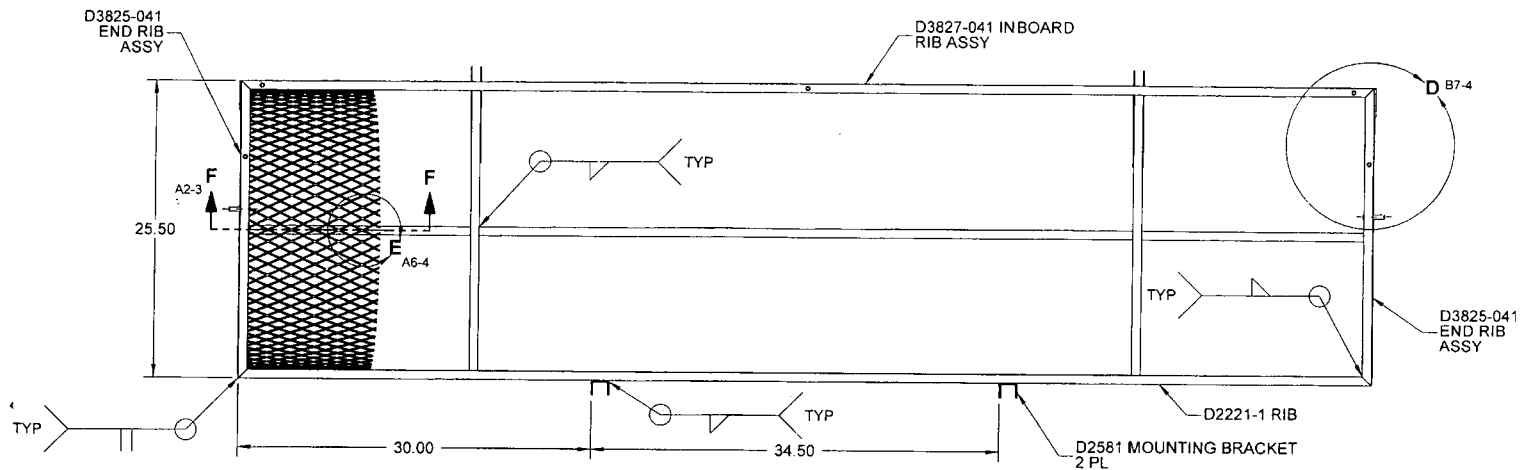
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

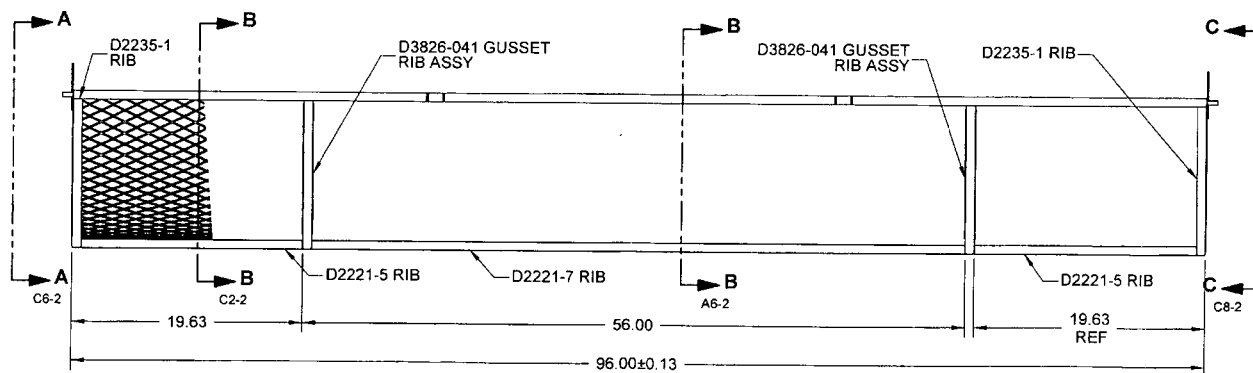
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D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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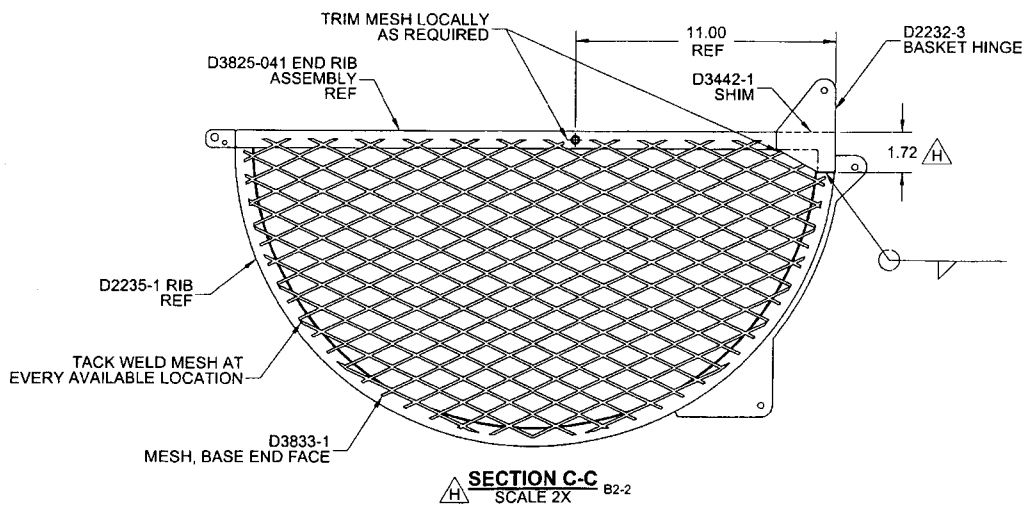
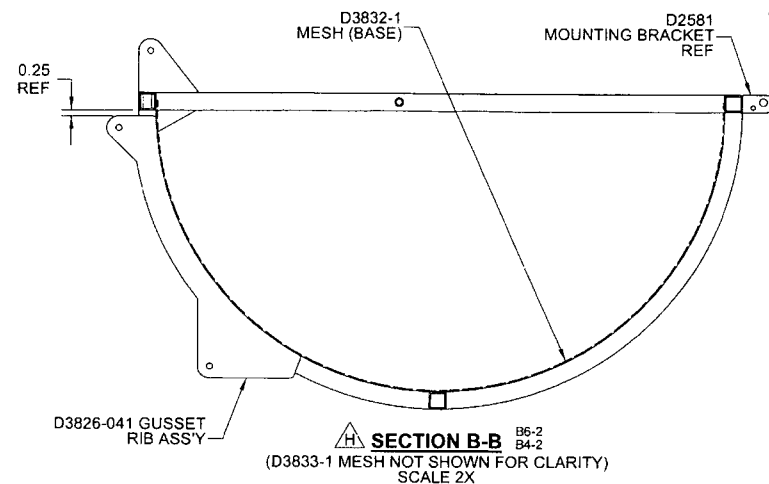
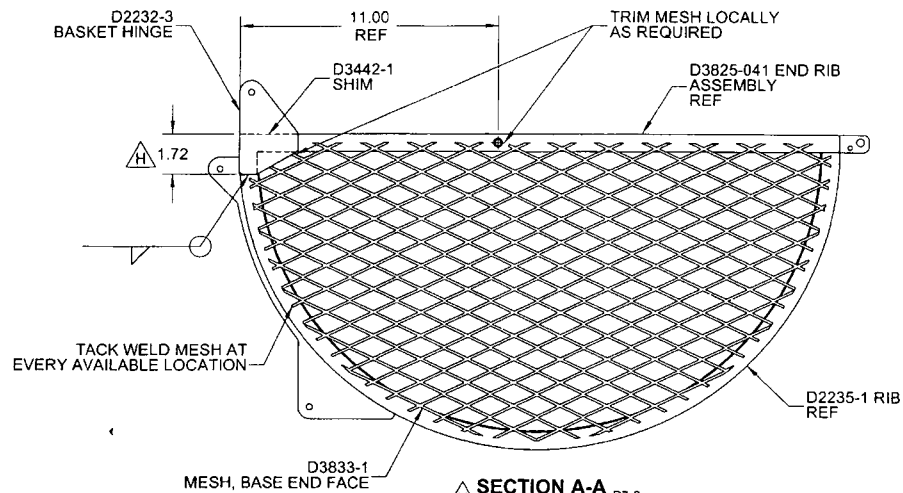
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NOTE: Date & initial all entries



RELEASE
03/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	AM	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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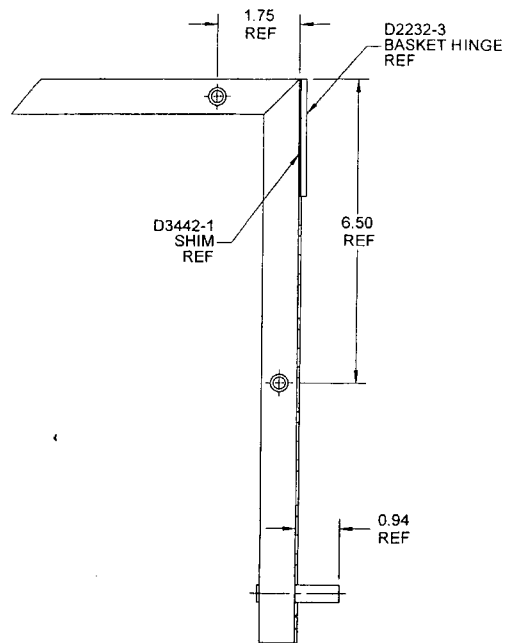
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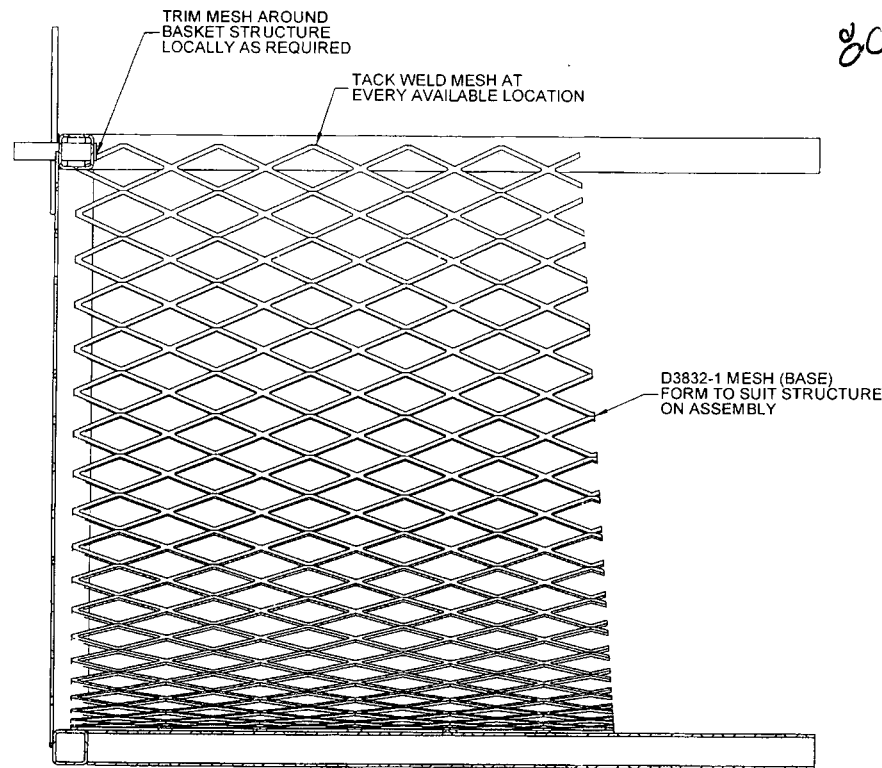
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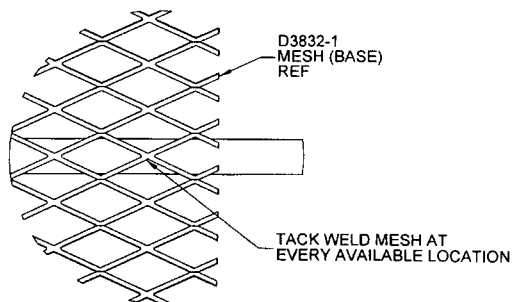
8 7 6 5 4 3 2 1



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2



DETAIL E
SCALE 4X C6-2

20811

RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	143	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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8 7 6 5 4 3 2 1

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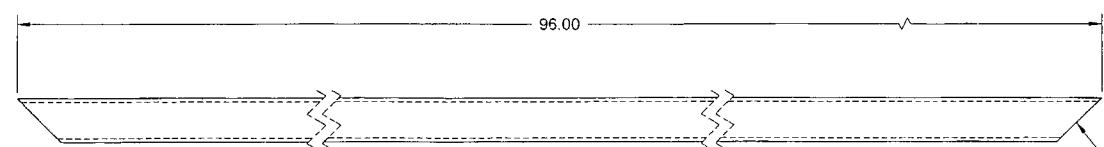
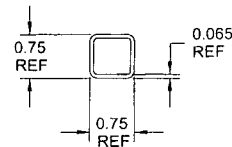
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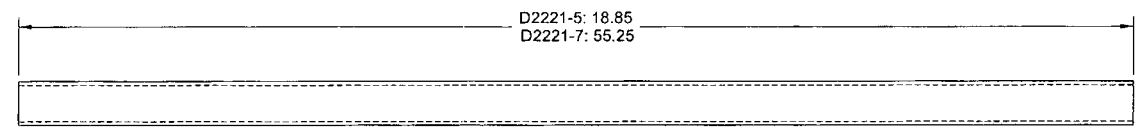
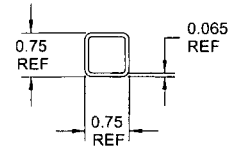
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80811



D2221-1 RIB

0.75 X 45° CHAMFER
2 PL



D2221-5/-7 RIB

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries